Friday, 7/20/2007 10:21:28 AM

Kim Johnston User

Process Sheet

Drawing Name

: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number **Estimate Number**

Customer

Prsht Rev.

: CU-DAR001 Dart Helicopters Services

: 33696

P.O. Number This Issue

: 10824 : MIA

: 7/20/2007

S.O. No. : NIA

Type : LARGE FAB ASSY

First Issue : 33463 Previous Run

Written By Checked & Approved By

Comment

: EST. REV. A 05.11.21

05.12.19

NEW ISSUE EC updated pick list EC

: D412630032 Part Number

: D412-630 REV.J, P17-19 **Drawing Number**

Project Number **Drawing Revision**

Material **Due Date**

Additional Product

Job Number:



EST. REV. B

Seq. #:

2.0

Machine Or Operation:

DOCUMENT CONTROL

1.0 DC



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001

SMALL & MEDIUM FAB RESOURCE 1

Description:

SMALL FAB 1

Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D412-630 p.17

*****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

07-08-02

3.0

D3463042

Step Weldment

Comment: Qtv.:

1.0000 Each(s)/Unit

Total: 3.0000 Each(s)

Pick:

Qty 1

Part Number D3463-042

Description

Batch

Step weldment

4.0

D3443043

Strut Weldment Assembly



Comment: Qty.:

1.0000 Each(s)/Unit

3.0000 Each(s)

Pick:

Part Number

D3443-043

Total:

D3443041

Qty

Description

Strut ass'y



Pick:

Qtv

Comment: Qty.:

1.0000 Each(s)/Unit

Total:

3.0000 Each(s)

Description Part Number D3443-041 Strut ass'y

B 33698 X 2mx

07-08-00

W/O:		WORK ORDER CHA	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A :	_ Date: _	
			ΟΔ.	N/C Close	d.	Date:	

NCR:			WORK ORDI	ER NON-CONFORMANO	E (NCR)			
		Description of NC		Corrective Action Section B		Verification		Annroyal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector
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Date: \ Friday, 7/20/2007 10:21:28 AM Kim Johnston User: **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 33696 Job Number: Description: Seq. #: Machine Or Operation: 6.0 D34439 Total: 6.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Pick: Part Number Description Qty D3443-9 Pin 2 SS Bolt 7.0 AN4CH3 Comment: Qty.: 6.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: Description Batch Qtv Part Number m10324 2 AN4CH3 **BOLT** A/R MS20995c41e Lockwire me AN4C14 **BOLT** 8.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Description Qtv Part Number m103248 **BOLT** 1 **AN4C14** 9.0 D34547 Bushing Comment: Qtv.: 6.0000 Each(s) 2.0000 Each(s)/Unit Total : Pick: Batch 1830225 x B mx, 1833701 x3mx. Qtv Part Number Description D3454-7 2 Bushing 10.0 AN3104 NUT Comment: Qty.: 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick:

Description

Nut

MF 07-08-02

m10364 x 2mg m105059 x 1 mx

Qty

1

Part Number AN310-4

W/O:		WORK ORDER	CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·					
Part No):	PAR #: Fault Category:	NCR: Ye	es No DG	A:	Date: _	

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORD	DER NON-CONFORMANO	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Annroval	Annzoval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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Date: \ Friday, 7/20/2007 10:21:28 AM User: Kim Johnston **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 33696 Job Number: Description: Seq. #: Machine Or Operation: COTTER PIN MS24665227 11.0 Comment: Qtv.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Part Number Description Qty m102073 **COTTER PIN** 1 MS24665-227 12.0 D34551 Spacer Comment: Qty.: 6.0000 Each(s) Total: 2.0000 Each(s)/Unit Pick: Qty Part Number Description Batch m 28171 2 Spacer D3455-1 13.0 D34651 3.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Total: Pick: 30308 x 1 mx, B 33-706 x dul Qty Part Number Description D3465-1 Washer 1 14.0 AN3107 NUT Comment: Qty.: 1.0000 Each(s)/Unit 3.0000 Each(s) Total: Pick: Qty Part Number Description Batch m103286 AN310-7 1 Nut 15.0 MS24665302 Cotter Pin Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Batch Qty Part Number Description M16941 1 MS24665-302 **COTTER PIN** mf.

W/O:		WORK ORDER C	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	
		· · ·	QA:	N/C Close	ed:	Date: _	

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Date: 1 Friday, 7/20/2007 10:21:28 AM User: Kim Johnston **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 33696 Job Number: Description: Seq. #: Machine Or Operation: INSPECT WORK TO CURRENT STEP 16.0 QC5 Comment: INSPECT WORK TO CURRENT STEP ****ensure tension to retract step is 11 to 18 lbs **** Test fit on aircraft in Eng. lab. PACKAGING RESOURCE # 17.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Pick Packing Kit 18.0 D34541 Bushing Comment: Qtv.: Total: 3.0000 Each(s) 1.0000 Each(s)/Unit Pick: Qty Part Number Description D3454-1 Bushing 1 D34543 19.0 Comment: Qty.: 2.0000 Each(s)/Unit 6.0000 Each(s) Total: Pick: Qty Part Number Description 2 D3454-3 Bushing D34545 Bushing 20.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s) Pick: Description Qty Part Number 2 D3454-5 Bushing 21.0 D34551 Spacer Comment: Qty.: 6.0000 Each(s)/Unit 18.0000 Each(s) Total: Pick: B28/7/ 1/5/2 SA Qty Part Number Description D3455-1 6 Spacer

W/O:		WORK ORDER CHANGE	5				
DATE	STEP	PROCEDURE CHANGE	· Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	
			QA:	N/C Close	d:	Date: _	

NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section E	}	Verification	Annroyal	Anneousl
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

Friday, 7/20/2007 10:21:28 AM Date: 1 Kim Johnston User: **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 33696 Job Number: Description: Seq. #: Machine Or Operation: 22.0 D34553 Total: 6.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Pick: Description Qty Part Number 2 D3455-3 Spacer D3462042 Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Batch 3 3 7 0 3 - 5 9 Part Number Description Qty D3462-042 Bracket ass'y 1 NUT AN3104 1.0000 Each(s)/Unit Total: per ASS. Description Part Number AN310-4 Nut Comment: Qty.: 6.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: Part Number Description AN310-5 Nut AN3C5A 26.0 Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s) Pick: Qty Part Number Description M100186 3 AN3-C5A Bolt AN44C12 evebolt M105161 -Comment: Qty. 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: Qty Part Number Description Batch

W/O:			WORK ORDER O	HANGES					
DATE	STEP	PR	OCEDURE CHANGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No	:	PAR #:	Fault Category:	NCR:	Yes	No DQ	A:	_ Date: _	
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NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section E		Verification	Annroval	Annroval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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Friday, 7/20/2007 10:21:28 AM Date: 1 Kim Johnston User: **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 33696 Job Number: Description: Seq. #: Machine Or Operation: Eyebolt 1 AN44-C12 BOLT 28.0 AN4C15 Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: M103248 Part Number Description Qty AN4C15 **BOLT** BOLT AN5C11 29.0 3.0000 Each(s) Comment: Qtv.: 1.0000 Each(s)/Unit Total: Pick: M103248 : 1 Qty Part Number Description **BOLT** AN5C11 1 BOLT AN5C15 Comment: Qty.: 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: Batch 50 M/05/60-1> Part Number Description Qty AN5C15 **BOLT** WAŞHER 31.0 AN960C10 Comment: Qty.: 7.0000 EACH(s)/Unit Total: 21.0000 EACH(s) Pick: Description Qty Part Number M101064 Washer AN960C10 WASHER 32.0 AN960C516 1.0000 Each(s)/Unit Total: Gemment: Qty.: 3.0000 Each(s) Pick: Qty Part Number Description M17.697 AN960C516 Washer

W/O:			WORK ORDER O	HANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault Category:	NCR: Yes	No DO	Δ.	Date:	

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORDI	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section E	1 Section B		Approval	Annroval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto
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Date: 1 Friday, 7/20/2007 10:21:28 AM User: Kim Johnston **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 33696 Job Number: Description: Seq. #: Machine Or Operation: Nut MS210433 33.0 Comment: Qty.: Total: 9.0000 Each(s) 3.0000 Each(s)/Unit Pick: Description Qty Part Number 3 MS21043-3 Nut COTTER PIN MS24665227 2.0000 Each(s)/Unit 6.0000 Each(s) Comment: Qty.: Total: Pick: Part Number **Description** M102073, Qty MS24665-227 **COTTER PIN** 2 **COTTER PIN** MS24665229 35.0 Comment: Qty.: Total : 6.0000 Each(s) 2.0000 Each(s)/Unit Pick: Description Part Number Qty 2 MS24665-229 **COTTER PIN** NAS1515H5 Comment: Qty.: 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: Description Part Number Qtv 4105/35 NAS1515H5 Washer 37.0 QC4 Comment: INSPECT 100% KITS FOR COMPLETENESS PACKAGING RESOURCE #1 38.0 Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D4/12-630-0 Location: PPP Rev:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				*				
Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A: 🔙	Date: <u>≤</u>	9/08/0	

QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
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Date: '

Friday, 7/20/2007 10:21:28 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 33696

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description:

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



[hin/07.08.07.

W/O:		WORK ORDER CH	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		

FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

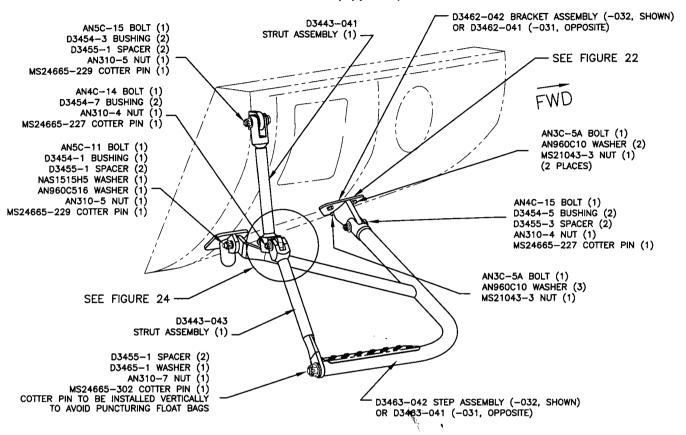
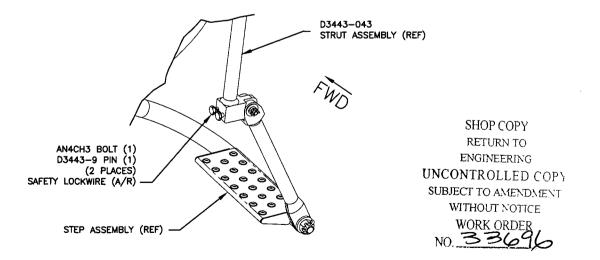


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH,Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)



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Revision:

K

Date: 06.10.05